

Work Order ID 73113

Thursday, August 25, 2011 4:10:36 PM



Page 1

Item ID: D206-581-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Handle Installation

Start Date: 8/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/08/26 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D206-581	C

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD206-581-015

CHG001

S nloc/31

CL 11-8-30

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

SP

SP 11-08-30

120 0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

S nloc/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73113

Thursday, August 25, 2011 4:10:36 PM



Page 2

Item ID: D206-581-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Handle Installation

Start Date: 8/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-581-015								
	Location: <u>3A</u>								
	PPP Rev: <u>A</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/8/31

10

11/8/31

mf

11-08-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 4:10:32 PM

Page 1

Work Order ID: 73113

Parent Item: D206-581-015

Parent Item Name: Step Handle Installation

Start Date: 8/26/2011


Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: Ipp Rev:A New Issue 10-07-16 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4103-1  Step / Handle		Manufactured	No			110	Each	1.0000	1	1			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--


Location	Loc Qty	Loc Code
----------	---------	----------

ENG	1	
60340	1	

80-005-3-8  Insert		Purchased	No			110	Each	19.0000	2	2			
--	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--


Location	Loc Qty	Loc Code
----------	---------	----------

ST379	19	
118003	19	

MS27039-4-11  Screw		Purchased	No			110	Each	73.0000	2	2			
--	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST292	73	
104016	49	
3355	24	

NAS1149D0416J  Washer		Purchased	No			110	Each	221.0000	2	2			
---	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

298	160	
118131	160	
ST298	61	
116513	61	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 4:10:32 PM

Page 2

Work Order ID: 73113

Parent Item: D206-581-015

Parent Item Name: Step Handle Installation

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

4,160.000

2 --- 2



Washer



sf sp 11-08-30.

Location

Loc Qty

Loc Code

ST298

4160

116025

16

116805

0

117291

1

117460

2

117591

108

118179

67

118384

2966

118612

1000

2x

Thursday, August 25, 2011 4:10:32 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PART LIST

5.1 D407-581-111/-011 AND D206-581-113/-013/-014/-015/-017 KITS

Qty -111	Qty -113	Qty -011	Qty -013	Qty -014	Qty -015	Qty -017	Part Number	Description
X							D407-581-111	PRE-FLIGHT KIT (407)
	X						D206-581-113	PRE-FLIGHT KIT (206A/B/L/L1/L3/L4)
2		X					D407-581-011	PRE-FLIGHT STEP KIT, LH/RH (407)
	1		X				D206-581-013	PRE-FLIGHT STEP KIT, LH (206A/B/L/L1/L3/L4)
	1			X			D206-581-014	PRE-FLIGHT STEP KIT, RH (206A/B/L/L1/L3/L4)
4	4				X		D206-581-015	STEP HANDLE KIT
						X	D206-581-017	RETENTION STRAP KIT
						2	D3031-3	LOOP
		1	1	1			D4101-041	PRE-FLIGHT STEP ASSEMBLY
			1				D4102-1	SHIM (206 LH)
				1			D4102-2	SHIM (206 RH)
		1					D4102-3	SHIM (407)
					1		D4103-1	STEP HANDLE
						1	D4104-041	DOUBLER ASSEMBLY
						1	D4105-1	STRAP
						2	80-004-2D8	INSERT
					2		80-005-3-8	INSERT
		6	6	6			80-005-3-16	INSERT
						8	CR3243-4-1	RIVET
						2	MS21042L3	NUT
						2	MS24694-S47	SCREW
						2	MS24694-S50	SCREW
						2	MS24694-S52	SCREW
					2		MS27039-4-11	SCREW
		6	6	6			MS27039-4-14	SCREW
						2	NAS1149D0332J	WASHER (or AN960JD10L)
		6	6	6	2		NAS1149D0416J	WASHER (or AN960JD416L)
					2		NAS1149D0463J	WASHER (or AN960JD416)